

Date: Wednesday, 1/11/2006 4:25:08 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT BRACKET
Job Number	: 25451		
Estimate Number	: 10260		
P.O. Number	: N/A	Part Number	: D23623
This Issue	: 1/11/2006 S.O. No. : N/A	Drawing Number	: D2362 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: E1
Previous Run	: 25073	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 1/18/2006
Checked & Approved By	: SEE COMMENT BELOW	Qty:	10
Comment	: Est: G 00.05.18 Added inspection level 8 EC	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2265	Step Support Casting
-----	-------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	625401-1

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: Machine per folio D2362-3

SD 06.01.28

9

P10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

SD 06.01.28

9

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

BG 06.01.30

9

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SD 06.01.28

9

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3




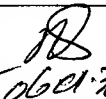
DL 06/01/30

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/31

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.01.28	2	- part hit by tool ↳ modify program. → done		Note both in Colia / Program changed	SA 06.01.28	 06.01.28		 06.01.30

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:25:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 25451

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*2006-01-31*

Comment: INSPECT POWDER COAT

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

*B25659 (5)*  
*B25469 (4)*

*ml 06/01/30*

9

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

*B25660 (5)*  
*B25470 (4)*

*ml 06/01/30*

9

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement  
as per Dwg D2362

Batch *M16194*

*ml 06/01/30*

9

11.0

QC5

INSPECT WORK TO CURRENT STEP



*2006-01-31*

Comment: INSPECT WORK TO CURRENT STEP

9

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *172*

*cd 06/01/31*

*(9)*

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



*ml 06-01-31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



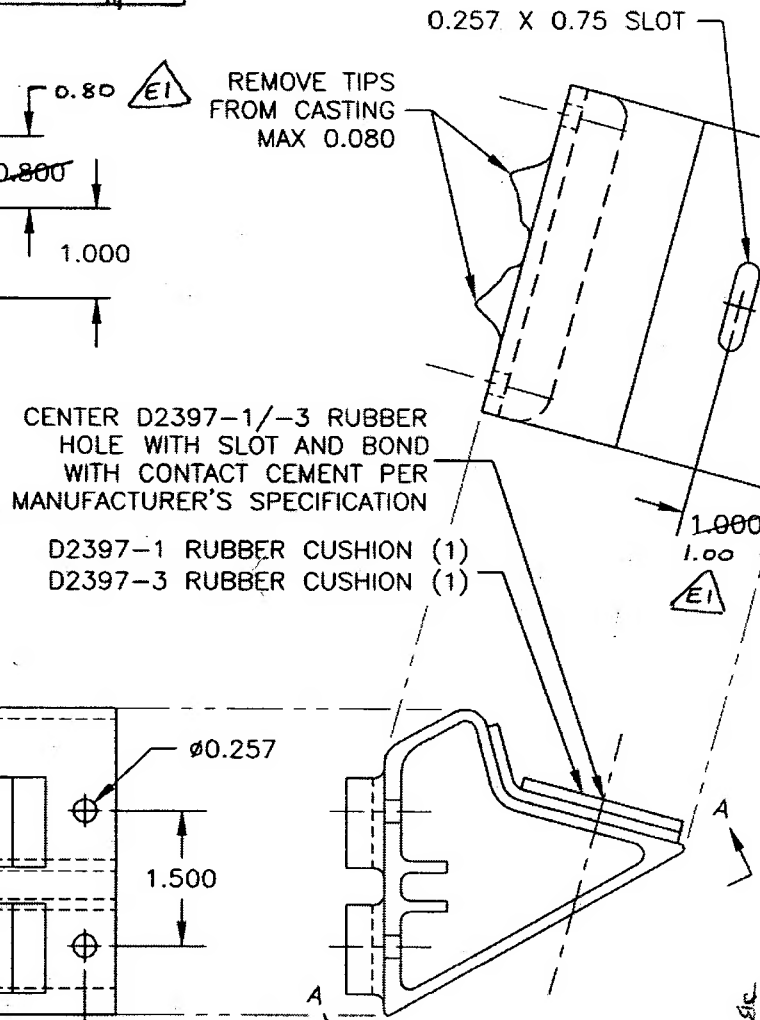
RELEASED  
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
KE	CP	D2362	
DATE	TITLE	STEP SUPPORT BRACKET	SCALE
98.12.04			1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

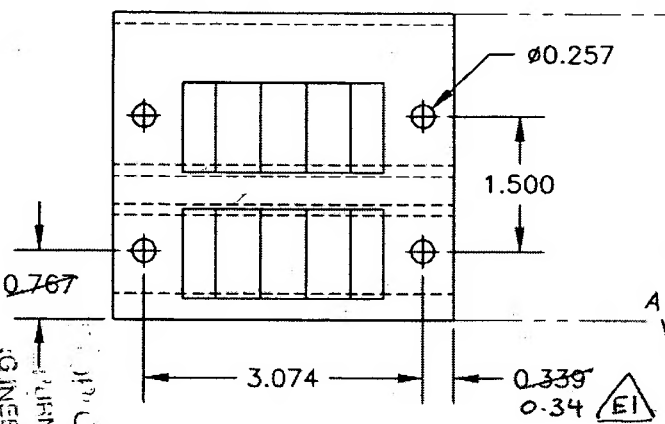
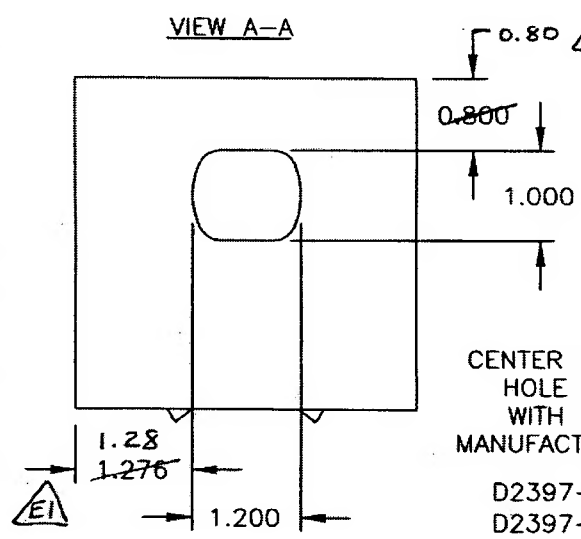
UNDER REVIEW

03.03.15 CP

DESIGN OK, BUT CHECK WITH  
D23 BEFORE MANUFACTURE  
OK 04/11/04



VIEW A-A



D2362-3

NOTES:  
1. IT ROLLED CO  
2. IT TO AMENDM  
3. WITH OUT NOTICE

MAKE FROM D2265  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright 1995 by DART AEROSPACE LTD

WORK ORDER

NO. 2448 25451



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3
KE	SP	D2362	
DATE	TITLE	SCALE	
98.12.04	STEP SUPPORT BRACKET	1:2	

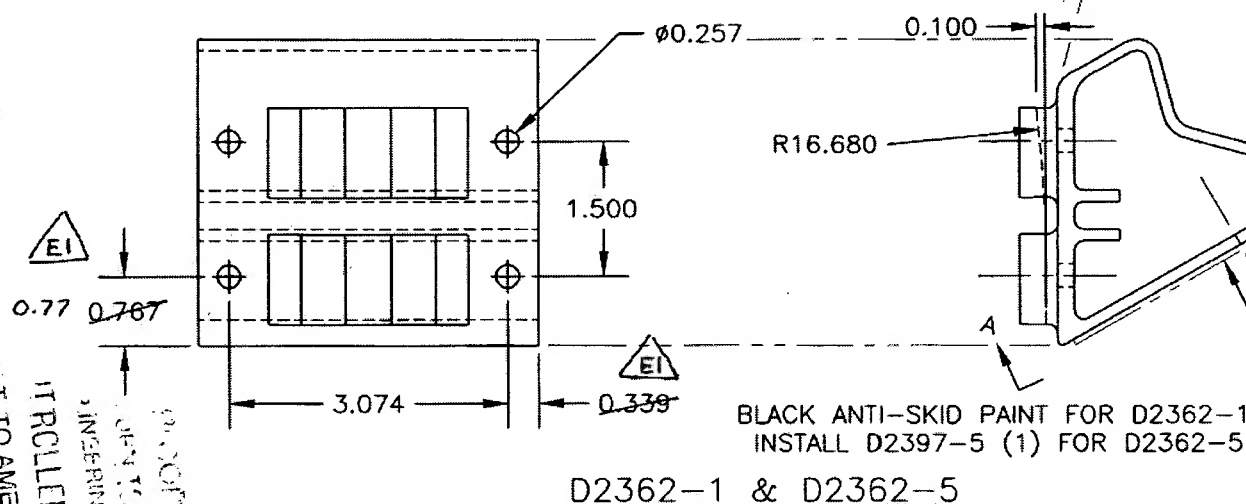
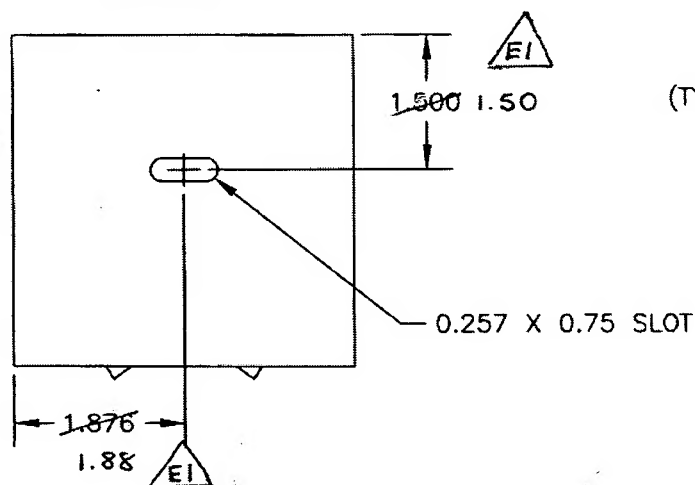
RELEASED  
98.12.14  
UNDER REVIEW

DESIGN OK, BUT CHECK BY  
OR BEFORE MANUFACTURE  
OK 1/2/05

MACHINE TO  
R1.100  
(TYP 2 PLACES)

REMOVE TIPS  
FROM CASTING  
MAX 0.080

VIEW A-A



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT  
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

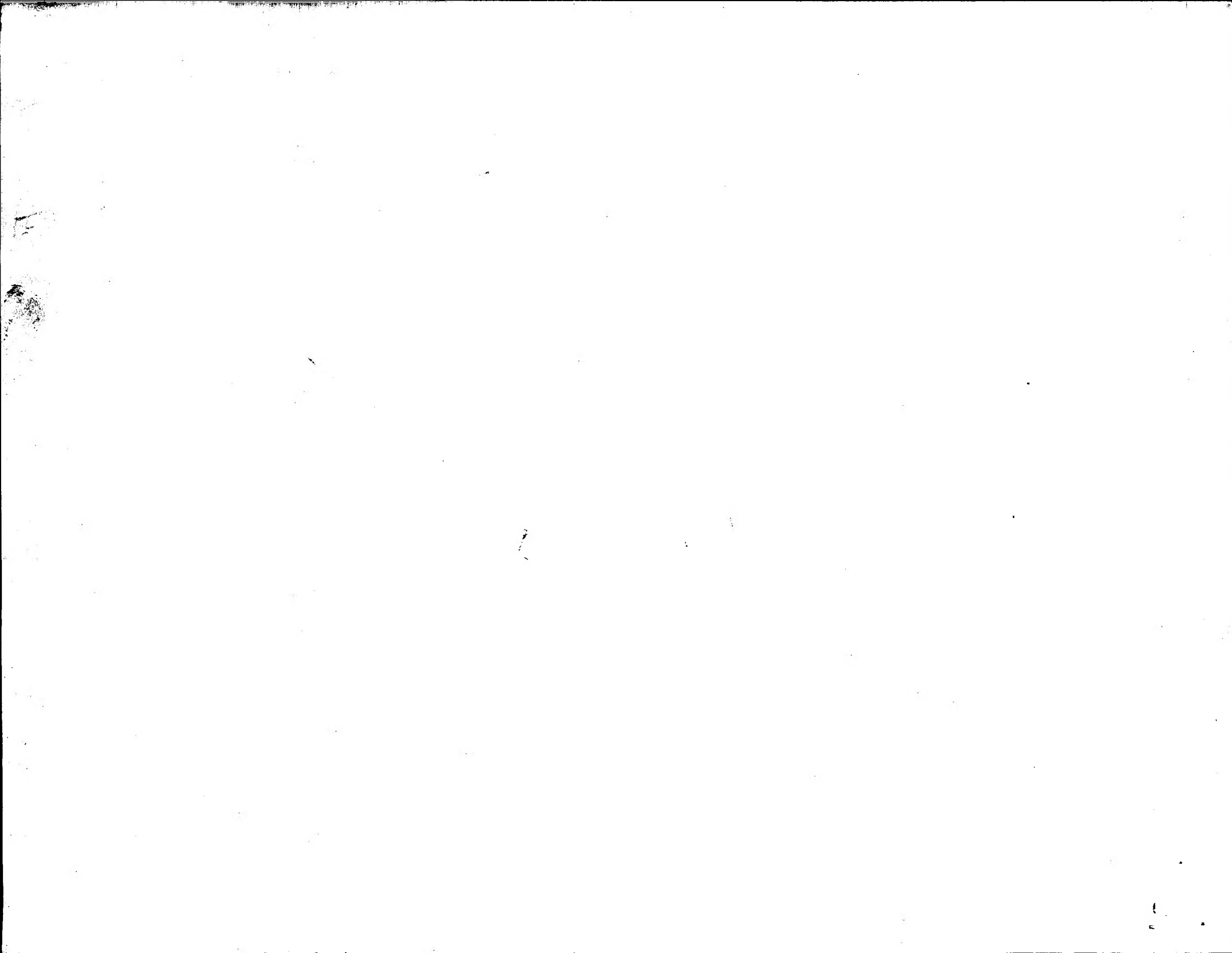
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright 1995 by DART AEROSPACE LTD WITH OUT NOTICE

WORK ORDER

NO. 25451

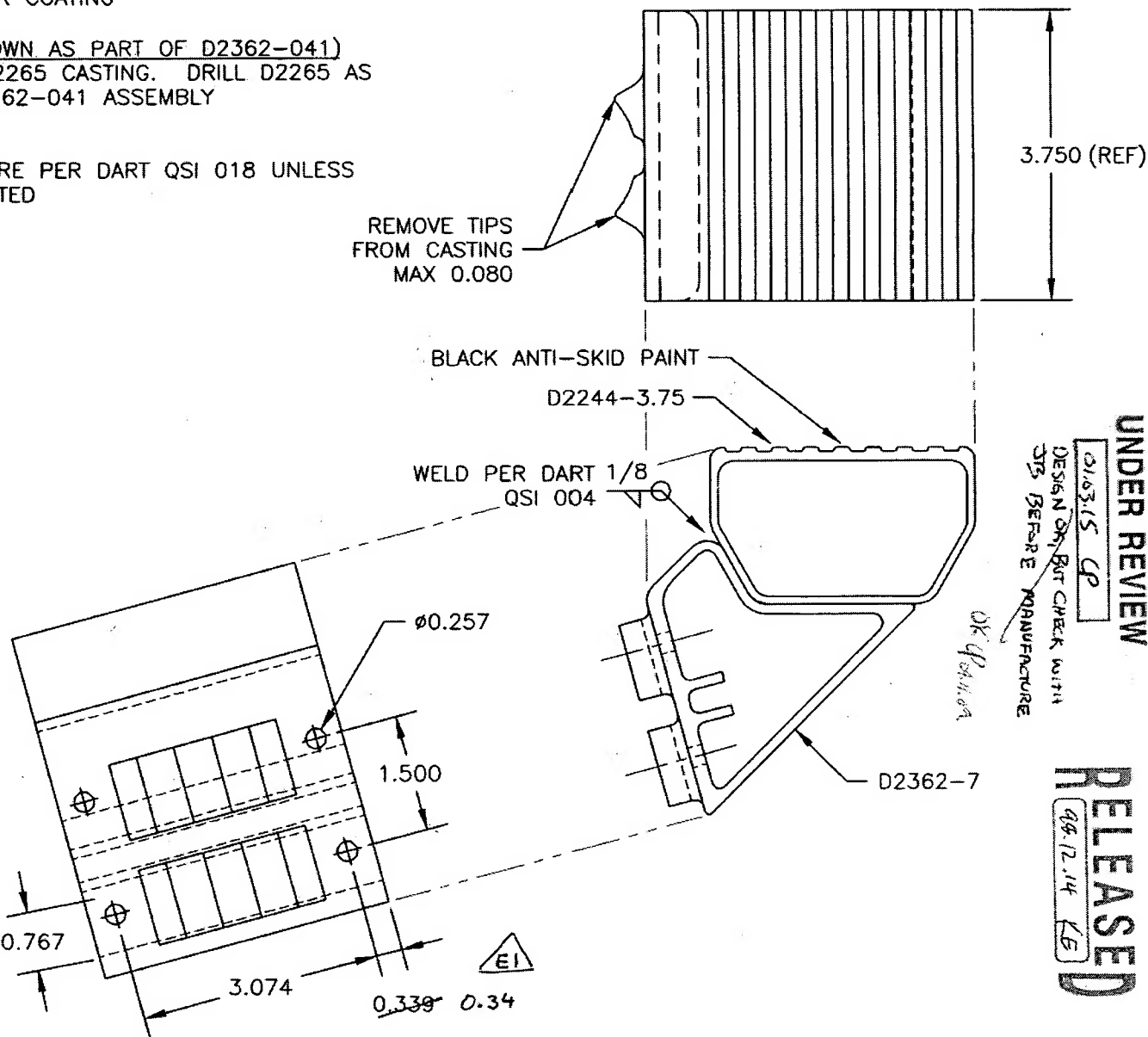


D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)  
MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:  
TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 3 OF 3
		SCALE 1:2

UNDER REVIEW

RELEASED  
98.12.14 KE

DESIGN ON BUT CHECK WITH  
DTS BEFORE MANUFACTURE





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 25451
<b>Description:</b>		<b>Part Number:</b>
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.80	$\pm .030$	.778	/			
1.000	$\pm .010$	1.002	/			
1.200		1.201	/			
1.28	$\pm .030$	1.267	/			
.257	$\pm$	.259	/			
.75	$\pm .030$	.760	/			
1.88		1.87	/			
1.00		.987	/			
$\emptyset .257$		$\emptyset .258$	/			
1.500	$\pm .010$	1.503	/			
.34	$\pm .030$	.338	/			
3.074	$\pm .010$	3.067	/			
.77	$\pm .030$					Cannot measure accurately

<b>Measured by:</b> SD	<b>Audited by:</b>	<b>Prototype Approval:</b>
<b>Date:</b> 06.07.28	<b>Date:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	